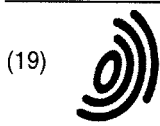


EXHIBIT A

[page intentionally left blank]



Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) **EP 0 674 800 B1**

(12) **EUROPEAN PATENT SPECIFICATION**

(45) Date of publication and mention
of the grant of the patent:
26.03.1997 Bulletin 1997/13

(51) Int Cl.⁶: **G21C 21/02**, G21C 3/20,
C22F 1/00

(21) Application number: **94903202.3**

(86) International application number:
PCT/SE93/01070

(22) Date of filing: **15.12.1993**

(87) International publication number:
WO 94/15343 (07.07.1994 Gazette 1994/15)

(54) **MANUFACTURE OF ZIRCONIUM CLADDING TUBE WITH INTERNAL LINER**

ERZEUGUNG EINES ZIRKONIUMHÜLLROHRES MIT INNERER BESCHICHTUNG

PRODUCTION D'UN TUBE DE GAINAGE EN ZIRCONIUM POURVU D'UNE CHEMISE
INTERIEURE

(84) Designated Contracting States:
CH DE ES LI SE

(72) Inventor: **DAHLBÄCK, Mats**
S-724 76 Västerås (SE)

(30) Priority: **18.12.1992 SE 9203871**

(74) Representative: **Boecker, Joachim, Dr.-Ing.**
Adelonstrasse 58
65929 Frankfurt am Main (DE)

(43) Date of publication of application:
04.10.1995 Bulletin 1995/40

(73) Proprietor: **ABB ATOM AB**
S-721 83 Västerås (SE)

(56) References cited:
EP-A- 0 121 204 **EP-A- 0 155 603**
EP-A- 0 194 797 **EP-A- 0 425 465**
SE-B- 459 340

EP 0 674 800 B1

Note: Within nine months from the publication of the mention of the grant of the European patent, any person may give notice to the European Patent Office of opposition to the European patent granted. Notice of opposition shall be filed in a written reasoned statement. It shall not be deemed to have been filed until the opposition fee has been paid. (Art. 99(1) European Patent Convention).

Description

TECHNICAL FIELD

The present invention relates to a method of manufacturing a nuclear fuel element comprising fuel rods the cladding tubes of which are provided with an internal liner of zirconium or a zirconium alloy.

BACKGROUND ART

A nuclear fuel element comprises fuel rods with cladding tubes filled with fuel pellets. It is known to provide cladding tubes with an internal layer of zirconium or a zirconium alloy to protect the fuel element from destruction caused by pellet-clad interaction, PCI, in case of rapid power increases.

SE 7810262 describes a nuclear fuel element with improved properties regarding the resistance to PCI and comprising a composite cladding container comprising an outer part of a zirconium alloy and an inner part, bonded to the outer part and consisting of zirconium with an impurity content of about 1000 to 5000 ppm.

This composite cladding tube is manufactured by inserting a sleeve of sponge zirconium, which is to be used as internal part, into a hollow billet of a zirconium alloy which is to constitute the outer part, whereupon the unit is subjected to explosion bonding of the sleeve to the billet. Thereafter, the composite product is extruded at a temperature of about 538 - 750°C while using conventional extrusion methods. Thereafter, the extruded composite product is subjected to a conventional tube production until the desired dimension of the cladding has been reached. The bond of the sleeve to the billet can also take place by means of heating to 750°C for 8 hours to achieve a diffusion bond. The manufacture of the composite cladding can also take place by extruding the unit, consisting of the inner sleeve and the outer shell, while using conventional technique.

EP 194 797 describes a cladding tube with an outer component and an inner component intended to protect the cladding against PCI damage. The inner component has a specific composition, zirconium with 0.4-0.6 % tin, 0.5-1.4 % iron and 100-700 ppm oxygen, in order to impart to the inner component good corrosion properties in the event that water should penetrate into the rod.

The cladding tube is manufactured by processing the ingot of the inner component in a conventional way for the manufacture of Zircaloy, including beta quenching, before the inner component is joined to the outer component. After the joining of the outer and inner components, the cladding tube can be additionally beta-quenched either before the last cold-rolling step by beta-quenching the outer surface, or before the penultimate rolling step by beta-quenching the entire cladding wall comprising both the outer and inner components.

EP 155 603 also describes a nuclear fuel element comprising a composite cladding tube with an internal

lining of zirconium to avoid cracking in the cladding upon thermal expansion of the pellets. According to this patent specification, it is known to reduce the sensitivity of the zirconium lining to cracking by limiting the total amount of impurities to a level below 5000 ppm and by maintaining the ratio of the oxygen content to the iron content greater than 1. The manufacture of a zirconium-lined cladding tube is performed by melting zirconium into an ingot which is then forged and shaped into a hollow billet. The hollow billet is inserted into another hollow billet of a zirconium alloy. The composite billets are heat-extruded into a tube blank. The tube blank is then subjected to repeated cold rolling operations and heat treatments according to conventional tube manufacture. A heat-treatment step consisting of a solution treatment at 800 or 860°C, near the phase transformation temperature to cause secondary phases in the material to become dissolved, and thereafter a rapid cooling to room temperature as well as a stress-removing heat treatment at a low temperature, for example 550°C for 2 hours, are carried out either after the forging or after the heat extrusion or as a last step on the finished tube, whereby it is considered to be especially effective to carry out the heat treatment as a last step. The best result is achieved according to the specification when the solution treatment is carried out in all the alternative steps during the process.

EP-A-0 425 465 describes a method for manufacturing cladding tubes of zirconium alloy, the outer surface of which is to obtain improved resistance to nodular corrosion during operation in a boiling reactor. The cladding tube is manufactured from a Zr-base alloy and is preferably beta-quenched before extrusion. Before the last cold-rolling step the outer surface of the tube is beta-quenched. After extrusion, thus, only an outer part of the tube is beta-quenched in order to impart to this part improved corrosion resistance. Such a tube can also be provided with an inner component for PCI protection. After extrusion, the inner component in such a case will not be affected by the beta quenching prior to the last rolling step.

SE 8301770-7 describes a fuel rod comprising a composite cladding tube with an internal layer consisting of sponge zirconium alloyed with 0.1 % tin. This fuel rod exhibits an increased resistance to the corrosive effect of water and water steam at elevated temperature. The cladding tube is manufactured by arranging a tube of the zirconium alloy, constituting the inner component, in a coarser tube of Zircaloy, the end surfaces of the two tubes being welded together. Thereafter, the composite tube is extruded without being subjected to any heating. The extruded product is then cold-rolled in several steps with intermediate recrystallization annealings at about 650°C and is finally annealed after the last cold rolling at about 525°C.

The inner side of the cladding tube can be subjected to the corrosive effect of water and water steam in those cases where damage occurs on the cladding, which

may result in water penetrating into the tube. The water will then become evaporated upon contact with the hotter fuel pellets. This results in the inside of the cladding tube being subjected to a corrosive effect of water/water steam of high temperature. When zirconium and zirconium alloys are corroded, hydrogen is formed, which to a certain extent is taken up by the cladding. The hydrogen will be precipitated in the form of zirconium hydrides. The zirconium hydrides are brittle and have a negative influence on the integrity of the tube. It is therefore of importance that the corrosion and the hydrogen absorption, caused by the corrosion, are as slight as possible in order not to risk that damage involving the penetration of water is extended such that a major quantity of water can penetrate through the tube and leaching of uranium dioxide and radioactive fission products can take place. Damage to a cladding tube can occur for several reasons, for example wear or defects in the welds.

The outer side of a fuel rod is always in contact with water and water steam, and it is known that heat treatments affect zirconium and the resistance of zirconium alloys to corrosion in water and water steam at a high temperature. Thus, a large number of publications describe heat treatments intended to improve the resistance of zirconium alloys to corrosion. EP 71193 describes how, during conventional manufacture, an ingot of a zirconium alloy is first forged in the beta-phase range and thereafter heat-treated in the beta-phase range followed by rapid quenching. Then, the billet is forged in the alpha-phase range and extruded, followed by tube manufacture involving cold-working steps and intermediate annealings in a conventional manner. To improve the corrosion resistance of the tube, it was found that the favourable solution treatment in the beta or alpha+beta-phase range followed by rapid quenching from the heat treatment temperature should be carried out also at a later stage in the process, after hot extrusion of the billet.

SUMMARY OF THE INVENTION

According to the present invention, it has been proved that a nuclear fuel element can exhibit an improved resistance to the effect of water and water steam in case of damage involving the penetration of water into a fuel rod provided with an internal liner layer by a careful choice, during the manufacture of the cladding tube, of parameters for heat treatment of the inner component from the very machining of an ingot of the inner component.

Surprisingly, it has been proved that also the heat treatments during the manufacture of the inner component into a composite cladding tube, which are carried out before the inner component is joined to the outer component to be extruded together, are of great importance for obtaining a fuel element with improved resistance to the corrosive effect of water and water steam

and where the harmful hydrogen absorption during the corrosion process is reduced, in the event that a cladding tube is damaged such that water can penetrate through the cladding.

It has also been proved, according to the present invention, that by choosing an optimum composition of the liner layer, the effect of manufacture, with chosen heat-treatment parameters for all the heat treatments, can be further improved.

According to the present invention, a fuel element comprising cladding tubes, with an internal layer, is to be manufactured by producing an ingot of zirconium or a zirconium alloy, for example zirconium-tin, suitable as inner layer in a PCI-resistant cladding. The ingot is machined by forging operations and possibly by rolling and extrusion into a suitable dimension to be joined to the outer component. To obtain optimum properties of the inner component, this component, during all the process steps after the manufacture of the ingot, such as forging, heat treatment, rolling, extrusion, intermediate annealing and final annealing, is to be maintained at temperatures lower than the temperature at which beta phase starts forming in the inner component.

An incipient transformation of alpha phase into beta phase takes place for zirconium with low oxygen contents, which is usually used as inner component in a PCI-resistant cladding, at 800°C. For zirconium-tin alloys, which are also used as inner component, tin stabilizes the alpha phase and the transformation temperature lies just above 862°C. During the formation of beta phase, a gradual dissolution of secondary phases, impurities and precipitated particles in the matrix takes place,

According to the present invention, the inner component should not be heat-treated at temperatures where beta phase is formed, and secondary phases and impurities should be prevented from dissolving in the matrix. This also applies to the early stage of the manufacturing chain, such as preheating, preliminary forging, and final forging.

For the manufacture of a nuclear fuel element according to the invention, an ingot is manufactured from the inner component. Ingots of zirconium are heat-treated in the alpha-phase range at 700-800°C and ingots of a zirconium-tin alloy are heat-treated in the alpha-phase range at 700-860°C before being forged. After that, a repeated forging operation with preheating within the same temperature interval in the alpha-phase range can take place. It is thus important that also the preliminary forging of the ingot take place at a temperature below the temperature at which an incipient transformation to beta phase takes place. An advantage of zirconium-tin alloys is that these can be heated to a higher temperature before the phase transformation takes place, which facilitates the machining of the ingot. Additional machining of the inner component, to obtain a suitable dimension of the inner component for joining to the outer component, is suitably carried out by hot rolling and extru-

sion. The temperature of the inner component should not exceed 710°C during these process stages.

A further improvement of the corrosion resistance of the inner component can be obtained by introducing additional heat treatment of a billet of the inner component in addition to the heat treatments which take place in connection with forging, rolling and/or extrusion, before it is joined to the outer component. This additional heat treatment is carried out in the alpha-phase range at 600-800°C for billets of zirconium and 600-860°C for 5 10 billets of zirconium-tin alloy and preferably within the interval 650-750°C, irrespective of the composition of the billet. This extra heat treatment can be carried out as a last step before the inner component is joined to the outer component or earlier in the process chain, for example before the inner component is extruded.

When the inner component has been machined into a suitable dimension, it can be joined to the outer component by passing a tube of the inner component into a coarser tube of the outer component in a conventional way.

The outer component consists of a zirconium alloy intended to constitute a supporting part of a composite cladding tube, for example Zircaloy 2 and zircaloy 4, whose contents of alloying materials lie within the limits 1.2-1.7% tin, 0.07-0.24% iron, 0.05-0.15% chromium and 0-0.08% nickel, the balance being zirconium and any impurities of a conventional kind or Zr 2.5 Nb. The outer component is machined in a conventional way by forging in the beta or alpha+beta-phase range followed by forging in the alpha-phase range and further degradation by forging and extrusion (if any). Before the outer component is joined to the inner component, the billet is beta-quenched by heating to the beta-phase range, for example 1050°C, and is thereafter rapidly cooled.

The composite billet consisting of an inner component and an outer component, is extruded at a temperature below 710°C.

After the extrusion, the tube blank is machined in a conventional way by means of a number of cold rolling steps with intermediate heat-treatment operations and a final heat treatment. Intermediate heat treatments of the inner component are performed within the interval 525-700°C and the final heat treatment is performed within the interval 400-700°C.

For the manufacture of a fuel element with cladding tubes with inner layers of zirconium, an extra heat treatment of the tube blank can be carried out after the inner component has been joined to the outer component. This heat treatment is carried out at in the alpha-phase range, suitably at 600-800°C. The limited diffusion of alloying materials which can take place between the outer component and the inner component during the heat treatment is not harmful to the PCI resistance of the layer. To ensure that a heat treatment of this kind does not have an adverse effect on the corrosion properties of the outer component, the outer part of the tube can be beta-quenched after the extra heat treatment has been

carried out. During beta quenching, the outer part of the tube is heated to a temperature in the beta-phase range, for example 1050°C and is then rapidly cooled.

The inner component can consist of pure zirconium or consist of a zirconium-tin alloy with 0.1 to 1% tin, such as an alloy of zirconium with 0.1-0.5% tin and with an iron content less than 550 ppm, preferably 200-450 ppm and less than 600 ppm oxygen. Impurities in zirconium and a zirconium-tin alloy shall be below the limits which normally apply to reactor-grade zirconium, namely, Al 75 ppm, B 0.5 ppm, C 100 ppm, Ca 30 ppm, Cd 0.5 ppm, Cl 20 ppm, Co 20 ppm, Cu 50 ppm, H 25 ppm, Hf 100 ppm, Mg 20 ppm, Mn 50 ppm, Mo 50 ppm, N 65 ppm, Na 20 ppm, Nb 100 ppm, Ni 70 ppm, P 30 ppm, Pb 100 ppm, Si 100 ppm, Ta 200 ppm, Ti 50 ppm, U 3.5 ppm, V 50 ppm, W 100 ppm and Cr 200 ppm.

The inner component can also consist of other zirconium alloys.

The invention will be explained in greater detail by description of an embodiment with reference to the accompanying figure which shows a flow diagram for the manufacture of a cladding tube.

An ingot of the inner component is manufactured (1). The inner component consists of zirconium with 0.25% Sn, 310 ppm Fe and 430 ppm O as well as impurity quantities normally occurring in reactor-grade zirconium. Thereafter, the ingot is preheated (2) and forged (3). These steps can be repeated by preliminary forging and finally forging the ingot. The ingot is preheated to a temperature of 820°C for 8 hours (2) and is forged (3), whereupon an additional heating to 800°C (2) and a final forging (3) are carried out. After forging, the billet is rolled down (4) and extruded at a temperature of about 670°C (5). Thereafter, the billet is annealed at 650°C for 5 hours (6).

The outer component is manufactured conventionally by forging and is beta-quenched before extrusion (7, 8, 9, 10, 11).

The inner component is joined to the outer component in conventional manner and the composite body is extruded (12) at a temperature of about 670°C. Thereafter, the tube blank is rolled in three stages into the final dimension with intermediate annealings at 570°C for 1 hour (13, 14). After the last rolling, the tube is finally annealed at 570°C for 1.5 hours (15).

The cladding tubes are filled with fuel pellets and sealed, whereupon they are assembled into bundles forming nuclear fuel elements intended for light-water reactors.

Claims

1. A method for manufacturing a nuclear fuel element comprising a composite cladding tube with an inner component of zirconium or a zirconium alloy suitable as inner component in a PCI-resistant composite cladding as well as an outer component of a zir-

- conium alloy intended to constitute the supporting part of a composite cladding tube, such as, for example, Zircaloy 2, zircaloy 4 or Zr 2.5 Nb, wherein the cladding tube is manufactured by fabricating an ingot of the composition of the inner component and an ingot of the composition of the outer component, respectively, and machining them separately into a billet of a suitable dimension and thereafter joining them together and extruding to a tube blank and machining it further by means of cold rolling and intermediate heat-treatment operations and a final heat treatment in the final dimension, **characterized** in that the inner component of zirconium or a zirconium alloy during the manufacture, from the production of an ingot up to the completion of a cladding tube, comprising forging, rolling, extrusion, heat treatment and final heat treatment, is only subjected to heat influence at temperatures in the alpha-phase range below the temperature when an incipient beta-phase transformation takes place.
2. A method according to claim 1, **characterized** in that the inner component is preheat-treated before the forging at a temperature in the alpha-phase range.
 3. A method according to claim 2, **characterized** in that the inner component is forged in two steps and that the preheat treatment before said steps is carried out at a temperature in the alpha-phase range.
 4. A method according to claim 1, 2 or 3, **characterized** in that the inner component is manufactured from a zirconium-tin alloy comprising zirconium with 0.1-1 % tin and preferably zirconium with 0.1-0.5 % tin and less than 600 ppm iron, preferably 200-450 ppm iron, and less than 600 ppm oxygen, as well as contents of impurities below the limits which normally apply to reactor-grade zirconium.
 5. A method according to claim 4, **characterized** in that an ingot of material intended to constitute the inner component is preheated at 700-860°C before forging of the ingot.
 6. A method according to claim 4 or 5, **characterized** in that the blank is heat-treated, in addition to the heat-treatment operations which are performed in connection with forging, rolling and/or extrusion, at 600- 860°C, preferably at 650-750°C.
 7. A method according to claim 1, **characterized** in that the inner component is manufactured from zirconium with impurity contents below those which normally apply to reactor-grade zirconium.
 8. A method according to claim 7, **characterized** in that an ingot of material intended to constitute the inner component is preheated to 700-800°C before forging of the ingot.
 9. A method according to claim 7 or 8, **characterized** in that the billet is heat-treated, in addition to the heat-treatment operations which are performed in connection with forging, rolling and/or extrusion, at 600- 800°C, preferably at 650-750°C.
 10. A method according to one or more of the preceding claims, **characterized** in that coextrusion takes place at a temperature below 710°C.
 11. A method according to any of the preceding claims, **characterized** in that the billet of the inner component is rolled and/or extruded at a temperature below 710°C.
 12. A method according to one or more of the preceding claims, **characterized** in that the extruded tube blank is cold-rolled in a number of steps with intermediate heat-treatment operations at 525-700°C and is finally heat-treated at 400- 700°C.
 13. A method according to one or more of the preceding claims, **characterized** in that, after extrusion, a heat treatment is carried out at 600-800°C.
 14. A method according to claim 13, **characterized** in that an outer part of the cladding tube blank is beta quenched after the heat treatment according to claim 13.
- ### 35 Patentansprüche
1. Verfahren zur Herstellung eines Kernbrennelements mit einem Verbundhüllrohr mit einer Innenkomponente aus Zirkonium oder einer Zirkoniumlegierung, die als Innenkomponente in einer gegen PCI widerstandsfähigen Verbundhülle geeignet ist, sowie mit einer Außenkomponente aus einer Zirkoniumlegierung, welche den tragenden Teil des Verbundhüllrohres bildet, wie zum Beispiel Zircaloy 2, Zircaloy 4 oder Zr 2,5 Nb, wobei das Hüllrohr hergestellt wird durch Fertigung eines Gußblockes mit der Zusammensetzung der Innenkomponente beziehungsweise eines Gußblockes mit der Zusammensetzung der Außenkomponente, wobei diese getrennt zu einem Rohling mit geeigneten Abmessungen verarbeitet werden und danach zusammengefügt und zu einem Rohrrohling extrudiert werden, der durch Kaltwalzen mit zwischenzeitlichen Wärmebehandlungen und einer abschließenden Wärmebehandlung in die Endabmessung gebracht wird, **dadurch gekennzeichnet**, daß die aus Zirkonium oder einer Zirkoniumlegierung bestehende Innenkomponente während der Herstellung, begin-

- nend mit der Fertigung eines Gußblockes bis zur Fertigstellung eines Hüllrohres, was Schmieden, Walzen, Extrudieren, Wärmebehandlung und abschließende Wärmebehandlung umfaßt, nur einer Wärmebeeinflussung bei Temperaturen im Alpha-Phasenbereich ausgesetzt wird, die unterhalb der Temperatur liegen, bei der eine anfängliche Beta-Phasenumwandlung stattfindet.
2. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß die Innenkomponente vor dem Schmieden einer Vorwärmebehandlung bei einer Temperatur im Alpha-Phasenbereich unterworfen wird.
 3. Verfahren nach Anspruch 2, **dadurch gekennzeichnet**, daß die Innenkomponente in zwei Schritten geschmiedet wird und daß die Vorwärmebehandlung vor diesen Schritten bei einer Temperatur im Alpha-Phasenbereich stattfindet.
 4. Verfahren nach Anspruch 1, 2 oder 3, **dadurch gekennzeichnet**, daß die Innenkomponente aus einer Zirkoniumlegierung hergestellt wird, die Zirkonium mit 0,1 bis 1 % Zinn, vorzugsweise Zirkonium mit 0,1 bis 0,5 % Zinn, und weniger als 600 ppm Eisen, vorzugsweise 200 bis 450 ppm Eisen, und weniger als 600 ppm Sauerstoff enthält sowie einen Verunreinigungsgehalt hat, der unter der Grenze liegt, die normalerweise für Zirkonium von Reaktorqualität gilt.
 5. Verfahren nach Anspruch 4, **dadurch gekennzeichnet**, daß ein Gußblock aus Material für die Innenkomponente vor dem Schmieden bei einer Temperatur von 700 - 860°C vorgewärmt wird.
 6. Verfahren nach Anspruch 4 oder 5, **dadurch gekennzeichnet**, daß der Rohling zusätzlich zu den Wärmebehandlungen, die in Verbindung mit dem Schmieden, Walzen und/oder Extrudieren stattfinden, bei 600 - 860°C, vorzugsweise bei 650 - 750°C, wärmebehandelt wird.
 7. Verfahren nach Anspruch 1, **dadurch gekennzeichnet**, daß die Innenkomponente aus Zirkonium mit einem Verunreinigungsgehalt hergestellt wird, der unter dem normalerweise bei Zirkonium von Reaktorqualität vorhandenen Verunreinigungsgehalt liegt.
 8. Verfahren nach Anspruch 7, **dadurch gekennzeichnet**, daß ein Gußblock aus einem für die Innenkomponente bestimmten Material vor dem Schmieden auf eine Temperatur von 700 - 800°C vorgewärmt wird.
 9. Verfahren nach Anspruch 7 oder 8, **dadurch gekennzeichnet**, daß der Rohling zusätzlich zu den Wärmebehandlungen, die in Verbindung mit dem Schmieden, Walzen und/oder Extrudieren stattfinden, bei 600 - 800°C, vorzugsweise bei 650 - 750°C, wärmebehandelt wird.
 10. Verfahren nach einem der vorhergehenden Ansprüche **dadurch gekennzeichnet**, daß die Koextrusion bei einer Temperatur unter 710°C stattfindet.
 11. Verfahren nach einem der vorhergehenden Ansprüche, **dadurch gekennzeichnet**, daß der Rohling der Innenkomponente bei einer Temperatur unter 710°C gewalzt und/oder extrudiert wird.
 12. Verfahren gemäß einem oder mehreren der vorhergehenden Ansprüche, **dadurch gekennzeichnet**, daß der extrudierte Rohling in mehreren Schritten kaltgewalzt wird mit zwischenzeitlichen Wärmebehandlungen bei 525 - 700°C und einer abschließenden Wärmebehandlung bei 400-700°C.
 13. Verfahren gemäß einem oder mehreren der vorhergehenden Ansprüche, **dadurch gekennzeichnet**, daß nach der Extrusion eine Wärmebehandlung bei 600 - 800°C stattfindet.
 14. Verfahren nach Anspruch 13, **dadurch gekennzeichnet**, daß der äußere Teil des Rohlings nach der Wärmebehandlung gemäß Anspruch 13 beta-abgeschreckt wird.

Revendications

1. Procédé de fabrication d'un assemblage combustible nucléaire comportant un tube gaine composite constitué d'un composant intérieur de zirconium ou d'un alliage de zirconium approprié en tant que composant intérieur dans une gaine composite résistant au PCI ainsi que d'un composant extérieur d'un alliage de zirconium destiné à constituer la partie support d'un tube de gainage composite, comme par exemple du Zircaloy 2, Zircaloy 4 ou du ZR 2,5 Nb, dans lequel le tube gaine est réalisé en fabricant un lingot de la composition du composant intérieur et un lingot de la composition du composant extérieur respectivement, et en les usinant séparément pour former une billette de dimensions appropriées et puis, en les réunissant et en les extrudant en une ébauche de tube et en usinant en outre cette ébauche en sa dimension finale au moyen d'opérations de traitement thermique intermédiaire et laminage à froid et d'un traitement thermique final, caractérisé en ce que le composant intérieur de zirconium ou d'un alliage de zirconium pendant la fabrication, de la production d'un lingot jusqu'à l'achèvement d'un tube gaine, comportant le forgeage, le

- laminage, l'extrusion, le traitement thermique et le traitement thermique final, n'est soumis à des influences thermiques qu'à des températures qui se trouvent dans la gamme de phase alpha en dessous de la température à laquelle une transformation de phase bêta naissante a lieu. 5
2. Procédé suivant la revendication 1, caractérisé en ce que le composant intérieur est prétraité thermiquement avant le forgeage à une température dans la gamme de phase alpha. 10
 3. Procédé suivant la revendication 2, caractérisé en ce que le composant intérieur est forgé en deux étapes et en ce que le prétraitement thermique avant ces étapes est réalisé à une température qui est située dans la gamme de phase alpha. 15
 4. Procédé suivant l'une des revendications 1, 2 ou 3, caractérisé en ce que le composant intérieur est fabriqué à partir d'un alliage zirconium-étain comportant du zirconium avec 0,1 à 1 % d'étain et de préférence du zirconium avec 0,1 à 0,5 % d'étain et moins de 600 ppm de fer, de préférence 200 à 450 ppm de fer, et moins de 600 ppm d'oxygène, ainsi que des teneurs en impuretés qui sont en dessous des limites qui s'appliquent normalement à du zirconium convenant pour un réacteur. 20 25
 5. Procédé suivant la revendication 4, caractérisé en ce qu'un lingot de matériau destiné à constituer le composant intérieur est préchauffé à 700 à 860°C avant le forgeage du lingot. 30
 6. Procédé suivant la revendication 4 ou 5, caractérisé en ce que l'ébauche est traitée thermiquement, en plus des opérations de traitement thermique qui sont réalisées en connexion avec le forgeage, le laminage et/ou l'extrusion à 600 à 860°C, de préférence à 650 à 750°C. 35 40
 7. Procédé suivant la revendication 1, caractérisé en ce que le composant intérieur est fabriqué à partir de zirconium avec des teneurs en impuretés qui sont en dessous de celles qui s'appliquent normalement à du zirconium convenant pour un réacteur. 45
 8. Procédé suivant la revendication 7, caractérisé en ce qu'un lingot de matériau destiné à constituer le composant intérieur est préchauffé à 700 à 800°C avant le forgeage du lingot. 50
 9. Procédé suivant la revendication 7 ou 8, caractérisé en ce que la billette est préchauffée, en plus des opérations de traitement thermique qui sont réalisées en connexion avec le forgeage, le laminage et/ou l'extrusion à 600 à 800°C, de préférence à 650 à 750°C. 55
 10. Procédé suivant une ou plusieurs des revendications précédentes, caractérisé en ce qu'une co-extrusion a lieu à une température située en dessous de 710°C.
 11. Procédé suivant l'une quelconque des revendications précédentes, caractérisé en ce que la billette de composant intérieur est laminée et/ou extrudée à une température en dessous de 710°C.
 12. Procédé suivant une ou plusieurs des revendications précédentes, caractérisé en ce que l'ébauche de tube extrudée est laminée à froid en un nombre d'étapes comportant des opérations de traitement thermique intermédiaire à 525 à 700°C et est finalement traitée thermiquement à 400 à 700°C.
 13. Procédé suivant une ou plusieurs des revendications précédentes, caractérisé en ce que, après l'extrusion, un traitement thermique est réalisé à 600 à 800°C.
 14. Procédé suivant la revendication 13, caractérisé en ce qu'une partie extérieure de l'ébauche de tube de gaine est trempée en phase bêta après le traitement thermique conforme à la revendication 13.

